

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE		
Job Number	: 44159				
Estimate Number	: 10618				
P.O. Number	:	Part Number	: D265637		
This Issue	: 18/12/2008	S.O. No.	:	Drawing Number	: D2656 REV D
Prsht Rev.	: NC			Project Number	: N/A
First Issue	: 18/12/2008	Type	: SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 43285			Material	:
Written By	:	Due Date	: 10/01/2009	Qty:	10
Checked & Approved By	: <u>JUP OR. 2.17</u>			Um:	Each
Comment	: Est Rev: D 02.10.25 Re-format KJ				
	: Est Rev; E 06-06-12 Now on Waterjet JLM				

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0 M1010S20GA 1010/1025 SHEET

Comment: Qty.: 0.5650 sf(s)/Unit Total : 5.6501 sf(s)
1010/1025 .040" SHEET
(M1010S20GA)
Batch: 110368 AB 9-1-8

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

Comment: FLOW WATER JET
1-Cut as per Dwg D2656
Dwg Rev: D
Prog Rev: D

2-Deburr if necessary HR 9-1-8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary.

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 18/12/2008 12:51:08 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 44159

Part Number: D265637

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326.

2- Identify as D2656-37

09/01/12

13

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/12

13

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

6:40

OVEN TEMPERATURE:

320°

FINISH TIME:

7:10

FL 09/01/13

13

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-13

13

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-20

FL 09/01/14

13

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/15

Job Completion



JW 09/01/14 13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44159
Description: Wearshoe		Part Number: D2656-37
Inspection Dwg: D2656 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

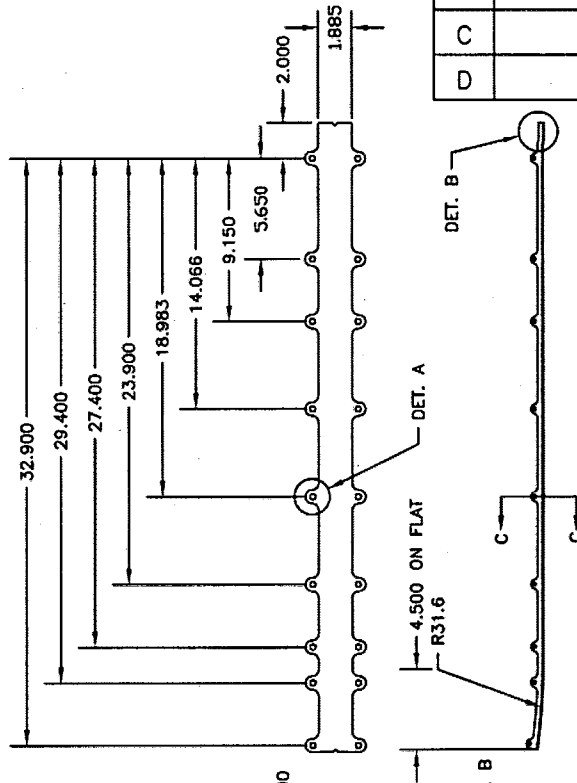
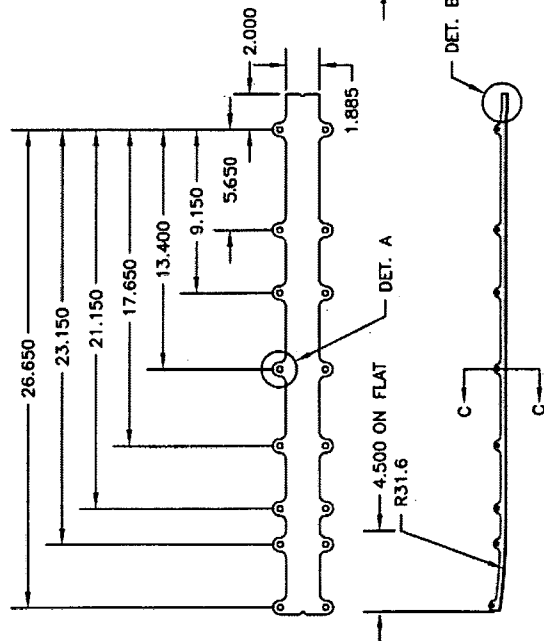
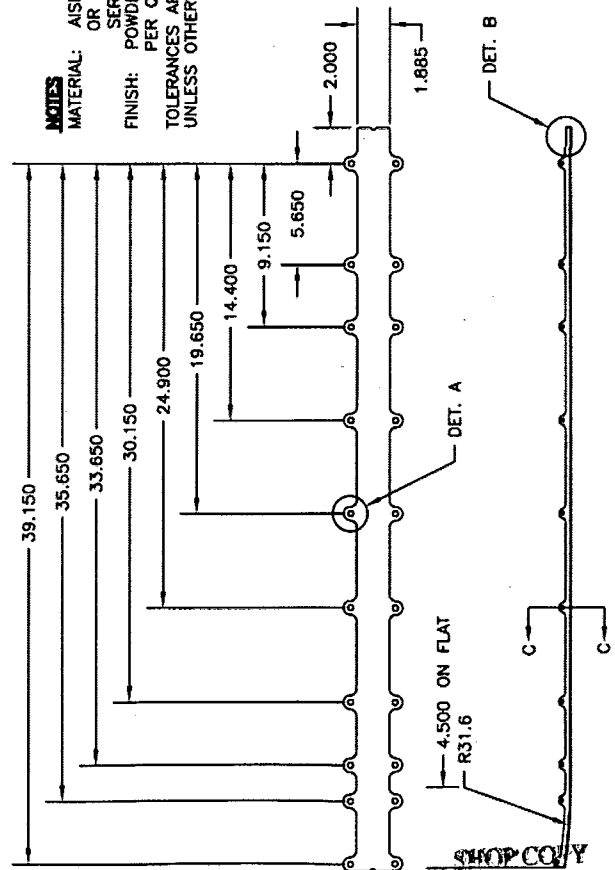
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300 x 0.300	+/-0.010	304X300	X			
1.885	+/-0.010	1.887	X			
2.000	+/-0.010	2.000	X			
4.750	+/-0.010	4.753	X			
9.500	+/-0.010	9.502	X			
14.250	+/-0.010	14.250	X			
17.750	+/-0.010	17.750	X			
22.500	+/-0.010	22.500	X			
27.250	+/-0.010	27.250	X			
30.750	+/-0.010	30.750	X			
0.040	+/-0.010	0.039	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-1-8	Date: 08/01/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	
B	08.11.27	Dimensions updated per Dwg Rev. D	KJ/EC	

DART

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				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25	NEW ISSUE			
B	97:06:02	CHANGED TABS			
C	97:06:26	R31.6 WAS R19.5			
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT			

D2656-13**D2656-11****D2656-15**

NOTES:
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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WORK ORDER

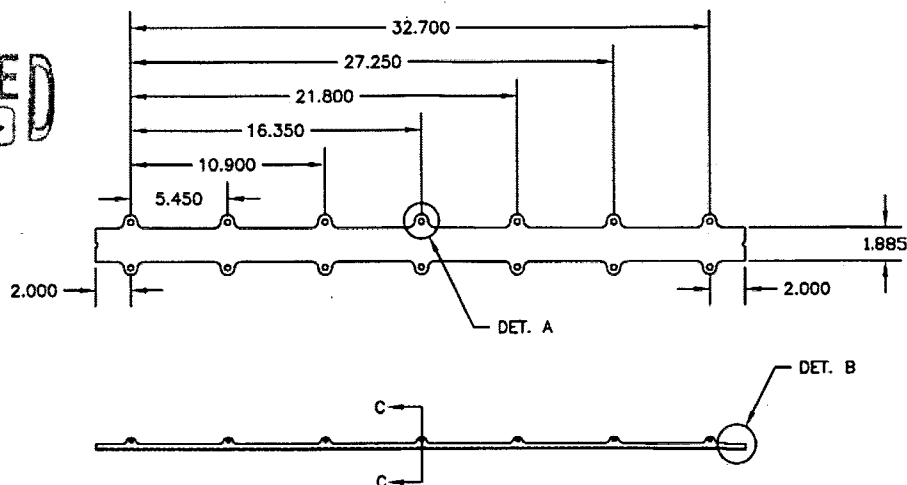
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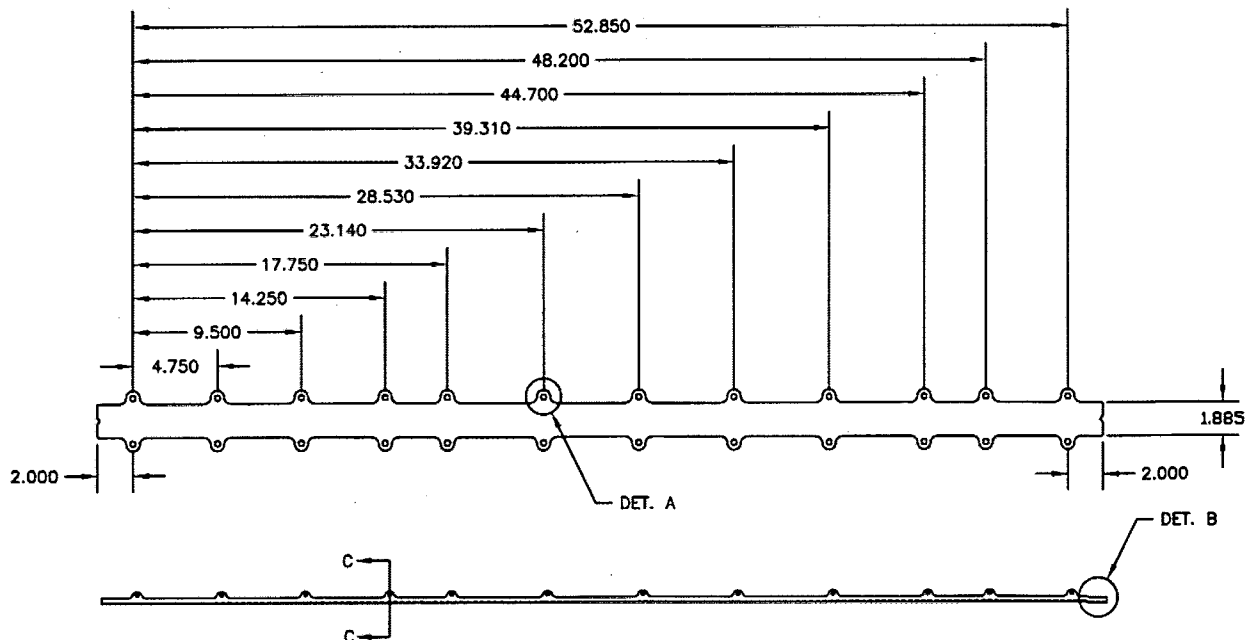
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
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FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
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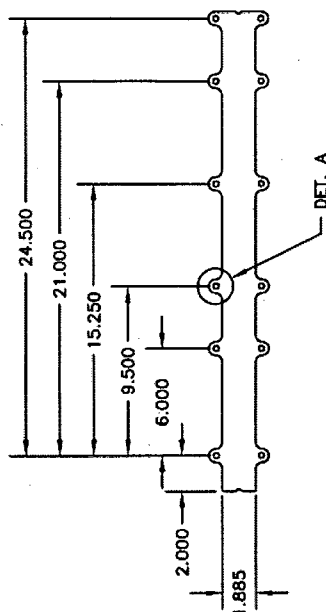
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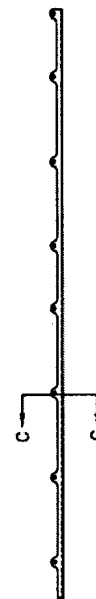
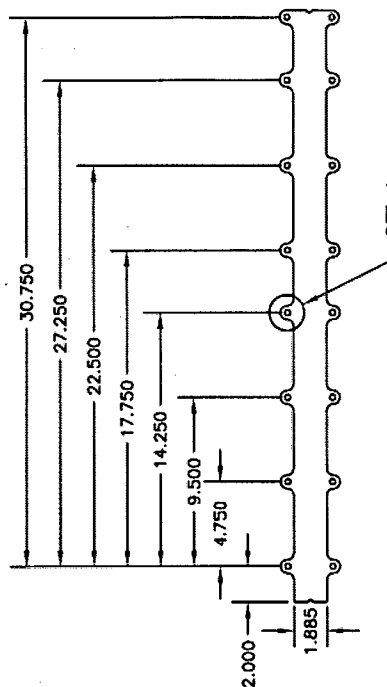


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DATE	05.08.17	TITLE	WEARSHOE	REV. D
				SHEET 3 OF 4
				SCALE 1:10

D2656-33

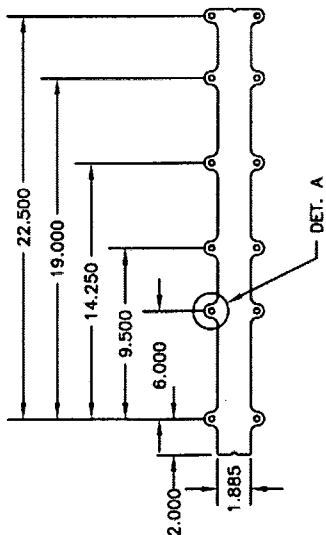


D2656-37

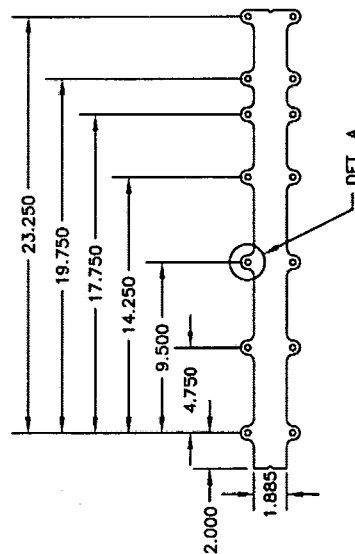


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D2656-35



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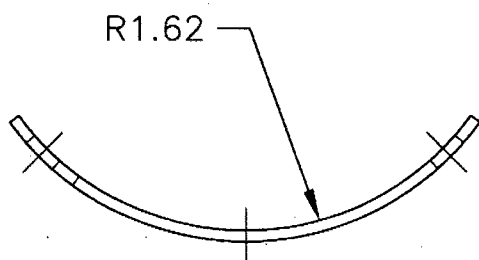
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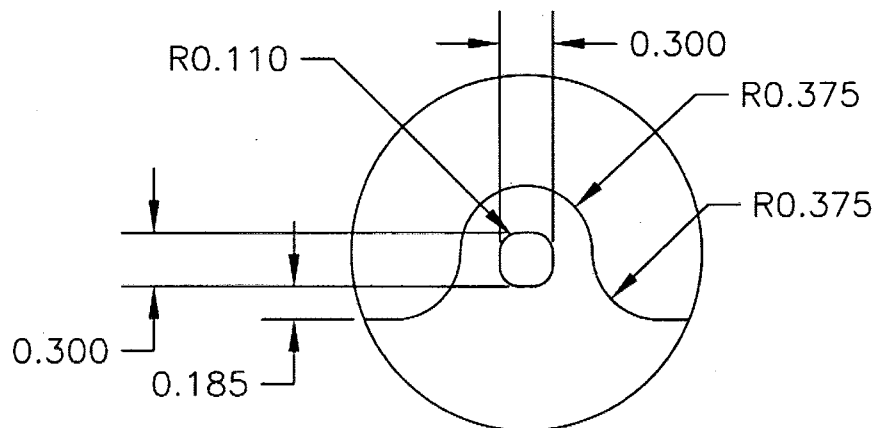
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

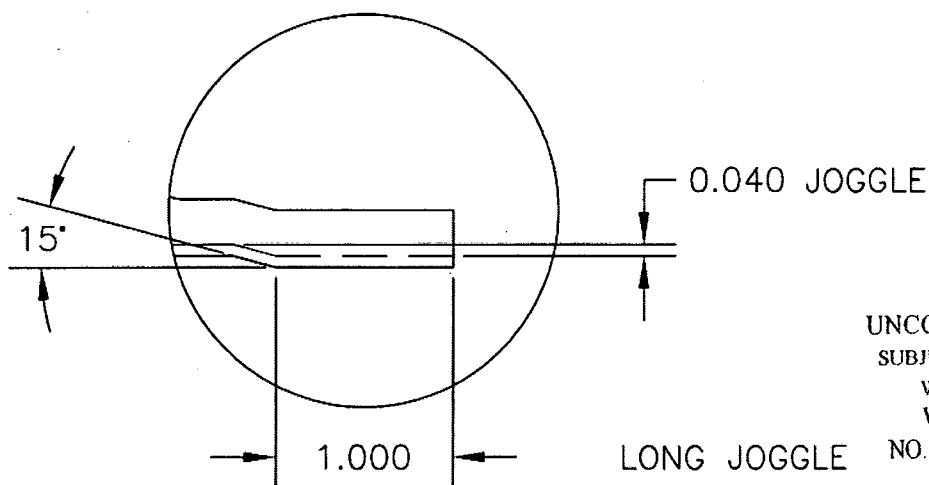


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DETAIL A



DETAIL B



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